

Date: Thursday, 29/06/2006 9:10:25 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 3.540" OUTER TUBE, NO RIDGE (BO 105)
<b>Job Number</b> : 27774	
<b>Estimate Number</b> : 12465	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D2962150
<b>This Issue</b> : 29/06/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D2962 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : NIA <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : NIA	<b>Material</b> : NIA
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 06/07/2006 <b>Qty:</b> 13 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>N</u>	
<b>Comment</b> : Est Rev:A New Issue 06-06-20 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

PG

PURCHASING



**Comment:** PURCHASING

Issue P/O: 1200

- a) Extrude as per Dwg D2962
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 125" long
- g) Bon L Canada Inc. tool # DAA-897127
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

U

29/05/06

2.0

D2962150P

3.540 Outer Tube, Extrut



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 13.0000 Each(s)  
3.540 Outer Tube, Extrut

3.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
Ensure material certification is attached

29/7/06 (13)

Date: Thursday, 29/06/2006 9:10:25 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3.540" OUTER TUBE, NO RIDGE (BO 105)

Job Number: 27774

Part Number: D2962150

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2962

Check Pull test per Dwg D2962 for compliance page attached.

Check hardness with Webster tester

26-07-07 (13)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

u 26-07-07

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(13)  
26-07-07

Job Completion



500 EDWARD AVENUE  
RICHMOND HILL, ON L4C 4Y9

06/14/06

141204

22071

Cust PO  
00001200

R/I No  
00307505

Lot  
22371010

Date  
6/14/06

Sold To  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

Ship To  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-3-2	150" MILL 6061 T6	D2962150
Gross Weight	103 KGS		
Net Qty	93 KG	13 PC	50 M 1 PKG
Specification	AMS-QQ-A-200/8 & ASTM B221-00		

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	323.5 / 46.9	298.0 / 43.2	10.0	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	NI	ZN	GA	V	TI	ZR	OTHER
.68	.25	.25	.07	.90	.06	.000	.07	.000	.009	.01	.000	.00

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Ritchie Bisnauth, QA Manager Signed for Bon L Canada

P.O. 1200

Date: Tuesday, 5/9/2006 9:13:25 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CC-DAR01	Drawing Name	: SKIDTUBE EC135 PROTOTYPE
Job Number	: 022A		
Estimate Number	: 10068		
P.O. Number	:	Part Number	: INITIAL PROTOTYPE
This Issue	: 5/9/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: P601-637
First Issue	: 1/1	Project Number	: P601-637
Previous Run	: 020A	Drawing Revision	:
Written By	:	Material	:
Checked & Approved By	:	Due Date	: 2/1/2006
Comment	: Project #: _____	Qty:	1 Um: Each
	Description: _____		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

- Issue P/O 1200  
 - TO BOWL

REFERENCE ONLY

2.0

D2962150

3.540 Outer Tube, Extrut



Comment: Qty.: 10.0000 (s)/Unit Total : 10.0000 (s)  
 3.540 Outer Tube, Extrut

2046/15 (13)

Tuesday, 5/9/2006 9:13:25 AM  
Linda Lacelle

## Process Sheet

Customer: CC-DAR01

Drawing Name: SKIDTUBE EC135 PROTOTYPE

Job Number: 022A

Part Number: INITIAL PROTOTYPE

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D2963125

105 I Beam Extrusion



Comment: Qty.: 10.0000 (s)/Unit Total : 10.0000 (s)  
105 I Beam Extrusion

*PU 6/6/15 (14)*

Job Completion



*QC 5/6 Inspect*

*26.06.28*

*B/14*

REFERENCE ONLY